

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2017-26** Date Opened: **02 February 2017** Title: **Assembly**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350** Product Type: **Cargo Basket** Product Model: **RH Medium** Quantity: **1****Work Order Contents**

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	JC
Completed Certification	JC
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76410	3	Basket Assembly	JC
70405	4	Lid Walkway Mod.	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC
76427	2	Placard	JC
84261	2	Handle Assembly	JC

Traveller

	Initial or N/A
Install walkway on lid	JC
Install lid on basket body	JC
Re-tap mounting lug holes and install mount lugs	JC
Install handle brackets	JC
Install handle	JC
Install lid prop	JC
Install data plate	JC

Component Completion

	As Instructed
Quantity Complete on This Work Order	1
Quantity Incomplete on This Work Order	0
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	JC
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 02-Feb-17

ICC / Dual Inspection performed by:

Print: J. Rekve

Sign: 

SCA: AD07

Date: 02-Feb-17

Work Order closed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 02-Feb-17

Approved Manufacturing Facility 73-04

Form 20.0.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0064
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-26
6. Item 1.	7. Description Cargo Basket Ass'y	8. Part Number 76410-01-01	9. Qty. 1	10. Serial/Batch No. 76401-15	11. Status/Work New
12. Remarks Modified with walkway on lid and front end cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i> AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature 14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 02 Feb 2017		14d. Name 14e. Date (dd/mm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

Sundance Helicopters



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: LD No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 69812-01 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-55

Remaining Tasks to be Performed: NONE

Signature: [Signature]

Date: 13 OCT 2016 Lic. No. / SCA AD02

Serviceable



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AMF 73-04

Remarks

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

76411-01-01

Aircraft:

Eurocopter

Model: AS350

Description:

Basket Body (R.H.)

Supplier:

Aero Design

Color:

White

WO#:

2008-15

PO# N/A

Jason Rekve

From: Donna Ayers <donna@asti-nc.com>
Sent: January 25, 2017 10:07 AM
To: 'Jason Rekve'
Subject: MATERIAL READY

Jason

Good afternoon, here is the info for your PO# 17005 so you can arrange the pick up.

1 box 244" x 8" x 8" @ 383#
2 boxes 247" x 8" x 8" @ 222#
total 3 boxes @ 605#

picking up @
AMERICAN STAINLESS TTUBING
129 HONEYCUTT ROAD
TROUTMAN, NC 28166
704-878-8823
800-908-8823

Let me know if you need anything else for this shipment.

Thank you
Donna Ayers
Traffic Manager
American Stainless Tubing, Inc
(704) 878-8823 ext 1221
donna@asti-nc.com

also
Tropics

Steven
Clawns

WPS

483

483 1010

Quebec

Globe co

Canada Post

7954 0950 9603 5794

0001 9482

-00-

6849-6257
20 lbs

Work Order: 2017-25Material Tracking Sheet
AS350 / AS355 Medium Basket Handle Assembly

1 of 1

Date Opened: 02 Feb 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/VO
	1	84261	84261-01	Handle Assembly		
Step 1				Weld Lever Assembly		2015-22
	.2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	.2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	.2		MS20615-4M3	Rivet		
	A/R		--	Welding Rod	ER308L TIG Rod	
Step 2				Clean Up	None	
Step 3				Fabricate Handle Bar		
	.1		36277-01	Handle Bar	304 Stainless, 1.0 x 0.035 Rnd. Tube	17005
Step 4				Weld Handle Assembly	None - Fuse weld, no rod req.	
Step 5				Clean Up	None	
Step 6				Inspection - Final Assembly	None	

Aero Design

Parts Distribution Sheet

Description: Basket Assembly Kit

WO# _____

[illegible]

Work Order: 2017-26Date Opened: 02 Feb 2017Material Tracking Sheet
Eurocopter AS350 / AS355
Medium Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		76410-01- <u>01</u>	Cargo Basket Assembly	(-01 RH, -02 LH) <u>S/N 76401-15</u>	
Step 1				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		<u>2016-55</u>
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	<u>15025</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		76427-01	Placard (right)	0.063 Sheet, 6061-T6 Aluminum	<u>2015-03</u>
	. . 1		76427-02	Placard (left)	0.063 Sheet, 6061-T6 Aluminum	<u>N/A</u>
	. . 4		CR3213-4-02	Cherry Rivet		<u>16053</u>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>17011</u>
	. . A/R		CR3213-4-02	Cherry Rivet		<u>16053</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		76411-01-XX	Basket Body Assembly		<u>2008-15</u>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<u>15075</u>
	. . 8		NAS1149F0663P	Washer		<u>15074</u>
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	<u>16030</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>16063</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>16053</u>
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2016-37</u>
	. . 4		AN3-11A	Bolt		<u>14068</u>
	. . 8		NAS1149F0363P	Washer		<u>16042</u>
	. . 4		MS21044N3	Nut		<u>16050</u>

Work Order: 2017-26Date Opened: 02 FEB 2017Material Tracking Sheet
Eurocopter AS350 / AS355
Medium Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		<i>see attached</i>
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	<i>15071</i>
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	<i>2016-132</i>
	.. 2		AN3-12A	Bolt		<i>15031</i>
	.. 4		NAS1149F0363P	Washer		<i>16042</i>
	.. 2		MS21044N3	Nut		<i>16080</i>
				<i>Lid Brace Installation</i>		
Step 5	. 1		36280-01	Brace Assembly		<i>2016-145</i>
	. 1		AN3-15A	Bolt		<i>14084</i>
	. 1		AN3-17A	Bolt		<i>13054</i>
	. 2		AN970-3	Washer		<i>15014</i>
	. 3		NAS1149F0363P	Washer		<i>16042</i>
	. 2		MS21044N3	Nut		<i>16080</i>
				<i>Inspection</i>		
Step 6					None	

CARGO BASKET ASSEMBLY - COMMON

2017-26

AS350 Med RH

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right) ←

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway ←

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2017-26

Date Open: 02 Feb 2017

AD
73-04
02

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

AD
73-04
02

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

AD
73-04
02

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

AD
73-04
02

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

6. Final Inspection

Dual inspection by a different person than assembled the basket.

a. Check for general condition and correct assembly:

- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

b. Check that PO/WO numbers have been recorded.

AD
73-04
01

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2017-26

Complete
(initial or SCA #)

Date Open: 02 Feb 2017

1. Weld Lever Assembly – handle lever jig required
 - a. Set MS20615-4M3 monel rivet into socket in jig
 - b. Set 36274-01 bushing into socket in jig
 - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
 - d. TIG weld around bushing using ER308L rod.
 - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
 - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
 - g. Record material POs on attached material list.

Previously c/w
w/o 2015-22
AD
73-04
02

2. Clean up
 - a. Clean lever assembly by media blasting with glass bead.
 - b. Drill out lever bushing to O (0.316) on lathe:
 - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
 - ii. Run at 300 RPM.
 - iii. Apply a drop of Rapid-Tap to drill.
 - c. De-burr.

3. Fabricate Handle Assembly
 - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
 - b. Measure across TOP side of levers.
 - c. Cut handle tubing to length measured.
 - i. Handles under 40" long: 1.0" x 0.035 round tube
 - ii. Handles over 40" long: 1.0" x 0.065 round tube
 - d. De-burr tube.
 - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
 - f. Record material PO on attached material list.

AD
73-04
02

4. Weld Handle Assembly
 - a. Fuse tube to lever on both ends. Ensure levers are parallel.

AD
73-04
05

5. Clean up
 - a. Clean welded area with scotch-brite.

AD
73-04
02

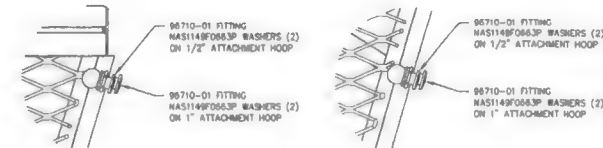
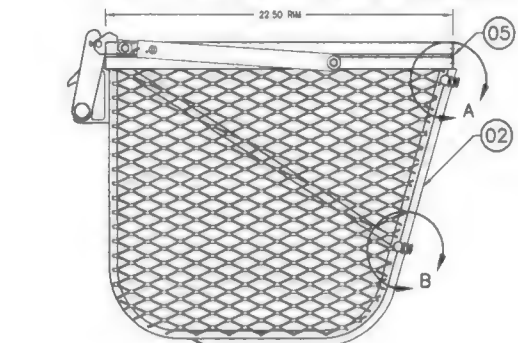
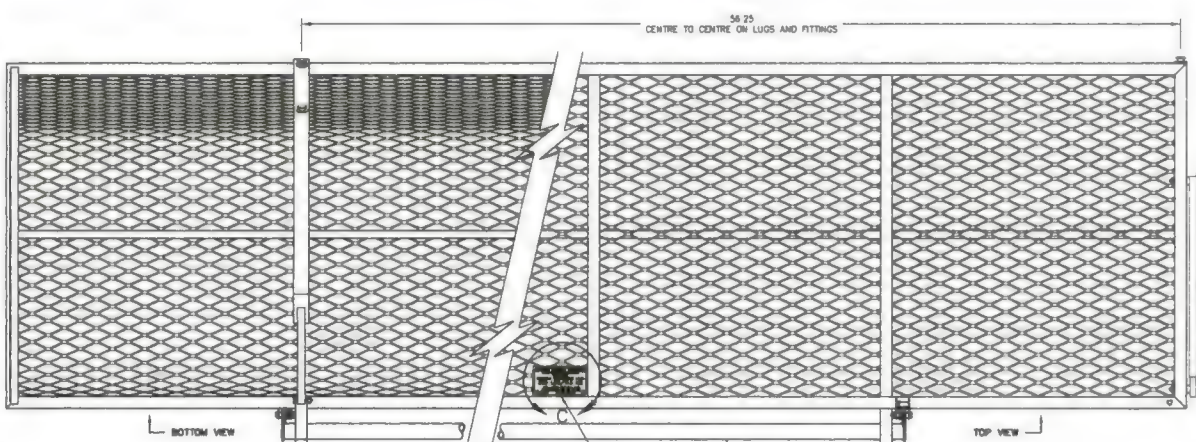
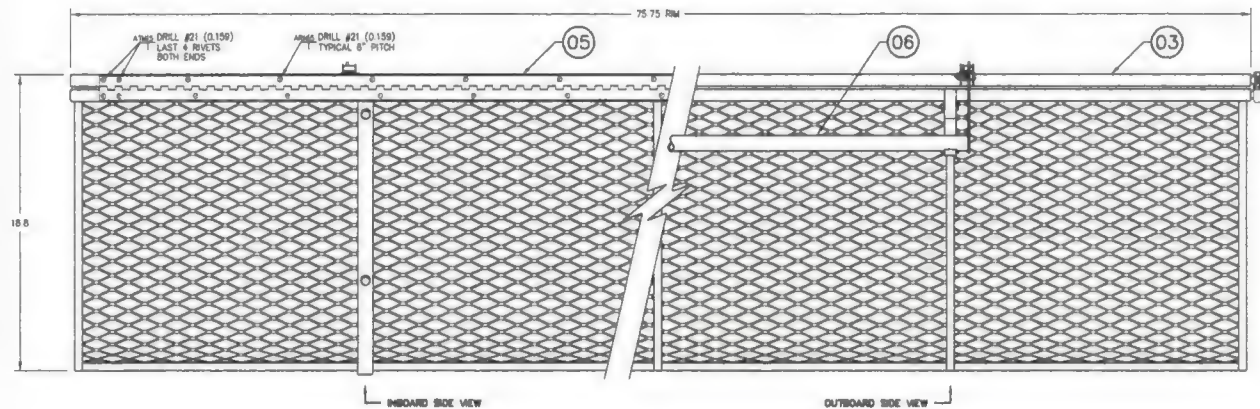
6. Final Inspection –

To be completed by a different person than the previous steps.

 - a. Welds for complete and handle for fit.
 - b. Tag complete and inspected parts in preparation for installation.

AD
73-04
01

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	14 JAN 08
1	ADDED LH ASSEMBLY	RR	05 MAR 09
2	CHANGED HANDLE CONFIGURATION	BJC	27 JAN 10
3	UPDATE TITLE BLOCK, ADD ALTERNATE REVIEWS, HANDMAKE P/N'S UPDATED.	BJC	10/07/2014
CHANGE BRACE ASSEMBLY TO INSTALLATION			

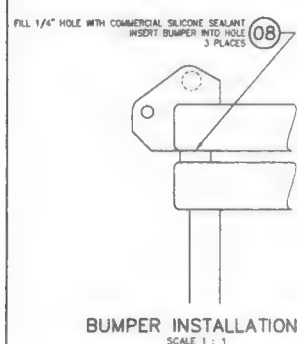


DETAIL A
SCALE 1 : 2
TYPICAL FRONT AND REAR

DETAIL B
SCALE 1 : 2
TYPICAL FRONT AND REAR

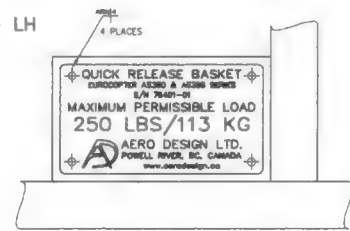
NOTE
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS SHEETS.

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	4	98710-01	WASHER	WASHER			
4	4	98710-01	CHERRY RIVET	CHERRY RIVET			
4	4	CR3213-5-02	CHERRY RIVET	CHERRY RIVET			
4	4	CR3213-4-02	CHERRY RIVET	CHERRY RIVET			
3	3	49205-14	BUMPER	BUMPER			
1	1	76427-02	07 PLACARD	07 PLACARD			
1	1	76427-01	07 PLACARD	07 PLACARD			
1	1	84255-01	06 HANDLE BAR INSTALLATION	06 HANDLE BAR INSTALLATION			
1	1	MS20001P4	05 PIANO HINGE	05 PIANO HINGE			72.0 LONG
1	1	84240-01	04 LID BRACE INSTALLATION	04 LID BRACE INSTALLATION			
1	1	69812-01	03 BASKET LID ASSEMBLY	03 BASKET LID ASSEMBLY			
1	1	76411-01-02	02 BASKET BODY ASSEMBLY (LH)	02 BASKET BODY ASSEMBLY (LH)			
1	1	76411-01-01	02 BASKET BODY ASSEMBLY (RH)	02 BASKET BODY ASSEMBLY (RH)			
1	1	76410-01-02	01-02 CARGO BASKET ASSEMBLY - LH	01-02 CARGO BASKET ASSEMBLY - LH			
1	1	76410-01-01	01-01 CARGO BASKET ASSEMBLY - RH	01-01 CARGO BASKET ASSEMBLY - RH			



BUMPER INSTALLATION
SCALE 1 : 1

76410-01-01 CARGO BASKET ASSEMBLY - RH
SHOWN
76410-01-02 CARGO BASKET ASSEMBLY - LH
OPPOSITE



DETAIL C
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF: NAS 523	M=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE	DRAWN: R RATHWELL	14 JAN 08
C-COUNTERSINK	DASH NO. FOR LENGTH	CHECKED: E BURGIN	
D=DEPTH DIGIT# OF SHEETS TO BE DIMPLED		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:	
BASIC CODES: BJ=MS20470AD BD=MS20426AD AD=CR3213 ATM=CR3523	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET	DECIMALS ANGLES X XXX ±0.010 ±1/2° X XX ±0.03 X X ±0.1	
LIST OF MATERIALS			
AERO DESIGN LTD. P.O. BOX 1400, MALAPINA ROAD POWELL RIVER, B.C. CANADA, V8A 0G3 TEL: 604 483 9376 www.aerodesign.ca			
EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY (MEDIUM)			
SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV
SHEET 1 OF 1	A1	76410	3

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG, ADD LEFT PLACARD (02)	BJC	JAN 27/10
2	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 76401-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"250 LBS/113 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"POWELL RIVER, BC, CANADA" - 0.080 HIGH
"www.aerodesign.ca" - 0.080 HIGH

- ON 76427-02: S/N IS 76402-XX.

DRILL #30 (0.129)
4 PLACES




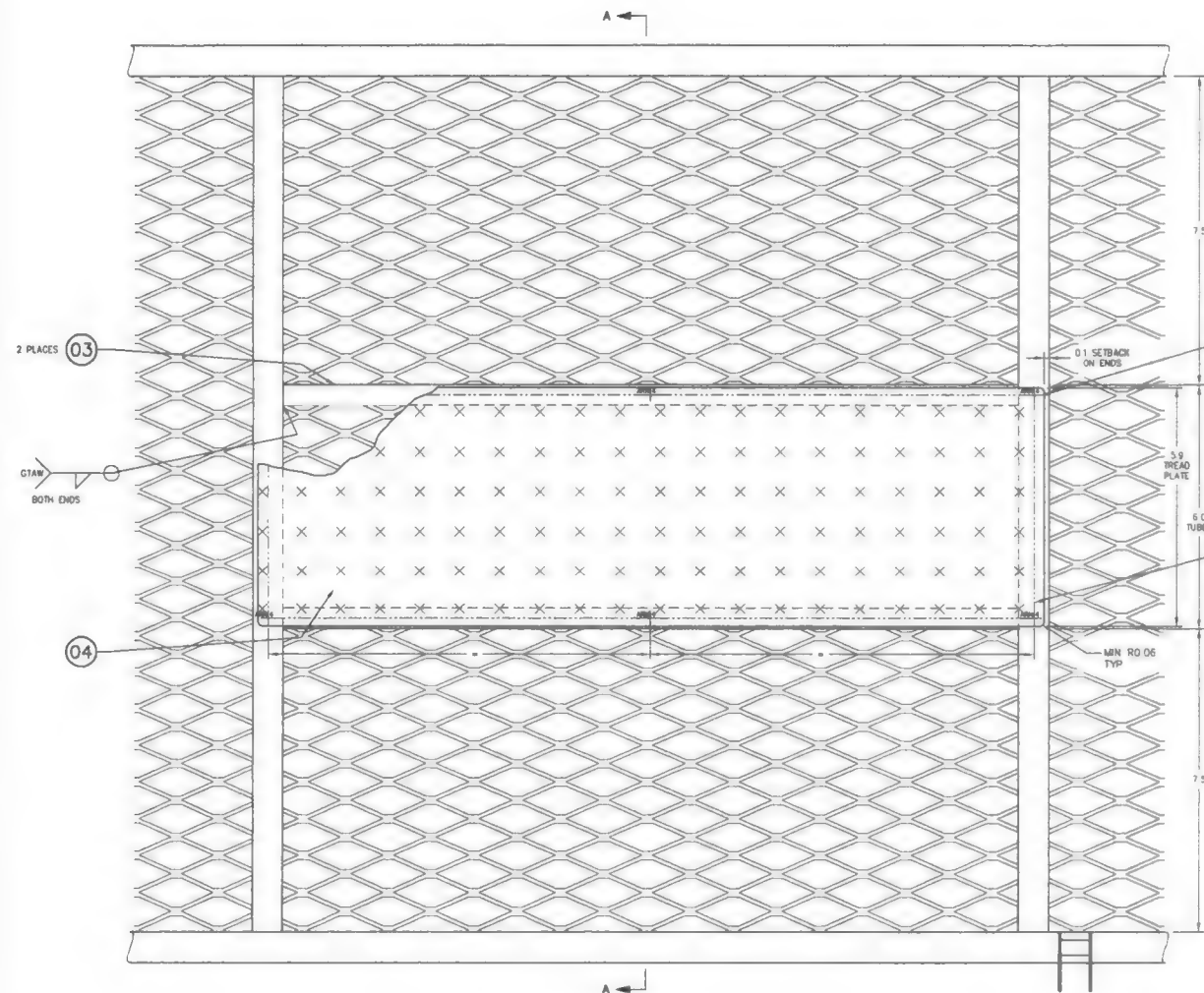
01 PLACARD

02 PLACARD

76427-02	02	PLACARD (LH)	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
76427-01	01	PLACARD (RH)	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1						
	SCALE 1 : 1 SHEET 1 OF 1						



01 BASKET LID ASSEMBLY

SECTION A-A

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS330 BASKETS. CHANGE TUBES	BUC	MAR 19/08
2	ADD EUROCOPTER EC135 MCDONNELL DOUGLAS MD600N BELL 208B BASKETS	BUC	DEC 4/08
3	ADD NEW AS330 AND 208L/407 MODELS	BUC	DEC 4/08
4	TITLE BLOCK UPDATED. MODEL LIST REMOVED. ADD ALT RIVET. ADD NOTE 7	BUC	28/05/2014

NOTES:

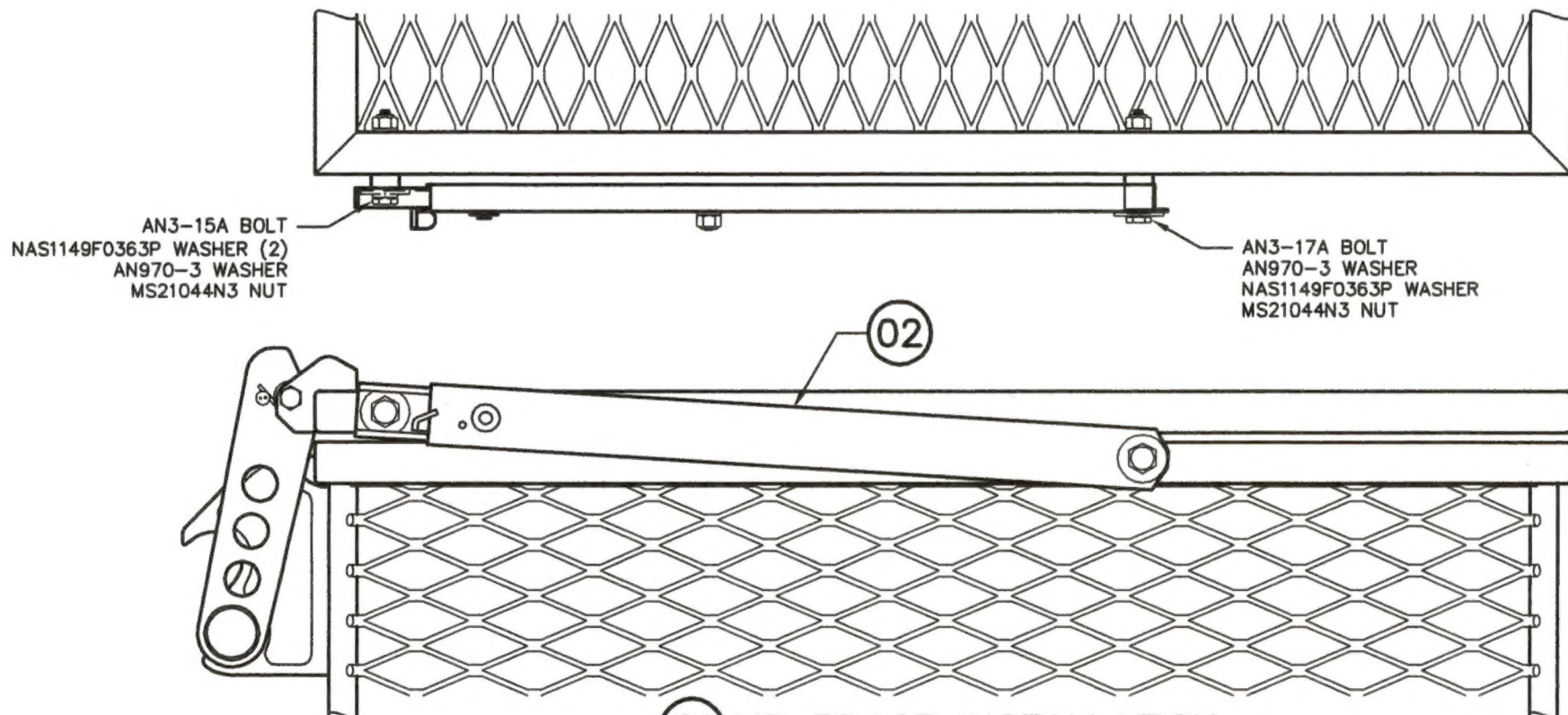
1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE	HR3213-4-02	
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.083 TREAD PLATE
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02 BASKET LID ASSEMBLY			
70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY					

BASIC CODE REF: NAS 523		DASH NO FOR DIAMETER N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE		DASH NO FOR LENGTH		APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E BURGOON		DATE 21 SEPT 2008	
C=COUNTERSUNK D=DIMPLE DIGIT # OF SHEETS TO BE DIMPLED		+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		AERO DESIGN LTD. 888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.3878 www.aerodesign.ca		CARGO BASKET LID STEP MODIFICATION	
BASIC CODES BJ=MS20470AD BB=MS20426AD ARN=CR3213 ARN=CR3212		SCALE 1:15 SHEET 1 OF 1		DWG NO A1 70405		REV 4			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



01 LID BRACE INSTALLATION

NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ± 0.010	$\pm 1/2^\circ$
X.XX ± 0.03	
X.X ± 0.1	

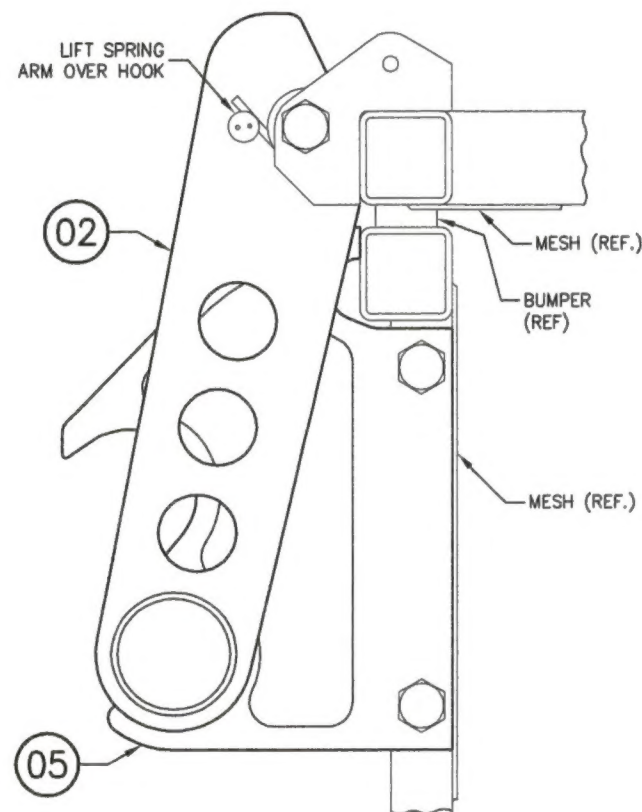
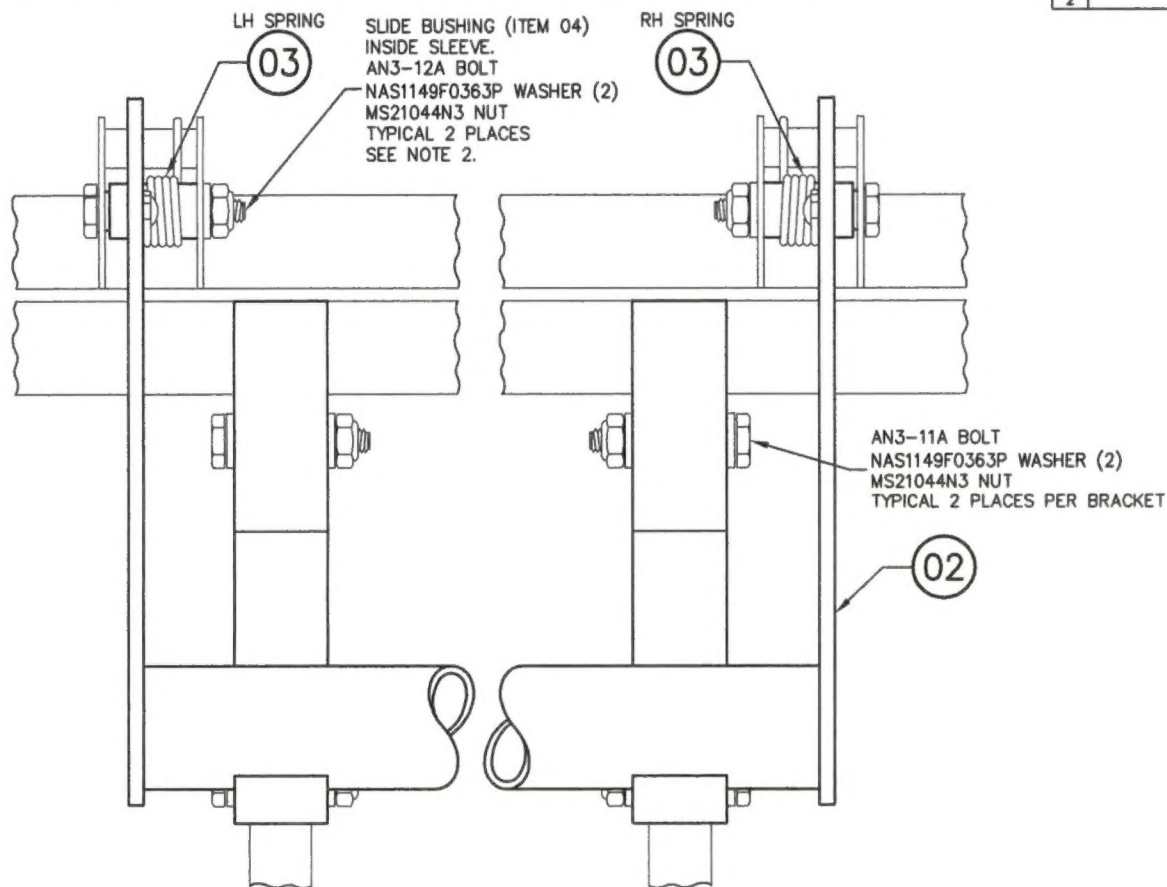
	AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.488.2376 www.aerodesign.ca		
HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION			
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14



(01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1



AERO DESIGN LTD.

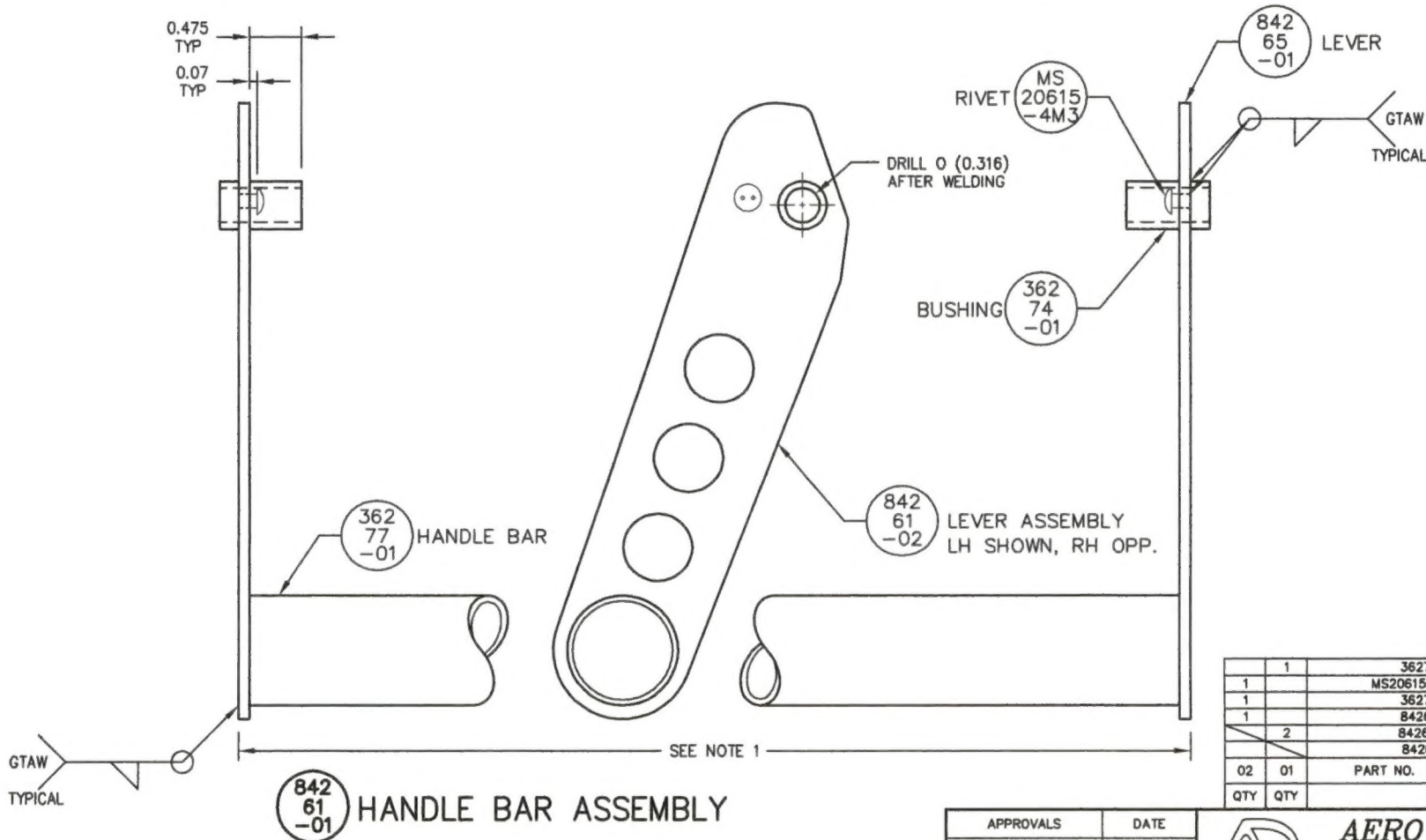
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.2376 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY
02	01		
LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



AERO DESIGN LTD.

9688A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.489.6376 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84261	2



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	50		
PN:	AN3-10A	Alt:	
Aircraft:	All	Model:	All
Description:	Bolt		
Supplier:	Aviall		
Color:	N/A		
WO#:	N/A		

13035 JK.
PO# Several